

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021136**Date Inspected:** 02-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Shi Gao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

This QA Inspector performed the following work:

OBG Segment 12AW

Shielded Metal Arc Welding (SMAW) in the 3G position of Deck LD to PP112.5 floor beam weld # DP3045-001-332 as per repair report # B-CWR1903. The welder is identified as 045246. ZPMC CWI is identified as Wu Shi Gao. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G(3F)-Repair. See attached photograph Pic_001.

OBG Segment 12AW

During in process inspection this QA Inspector observed ZPMC personnel performing Counterweight side LD alignment between PP111 & PP111.5.

OBG Segment 11DW – Blast shop 1

This QA inspector performed internal Visual Inspection of OBG Segment 11DW after Blasting in ZPMC Blast

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Shop # 1.

OBG Segment 12AW

This QA inspector performed Visual inspection (VT) on Deck Panel to Floor beam and 'U' rib welds of PP 110 East side.

OBG Segment 12AE

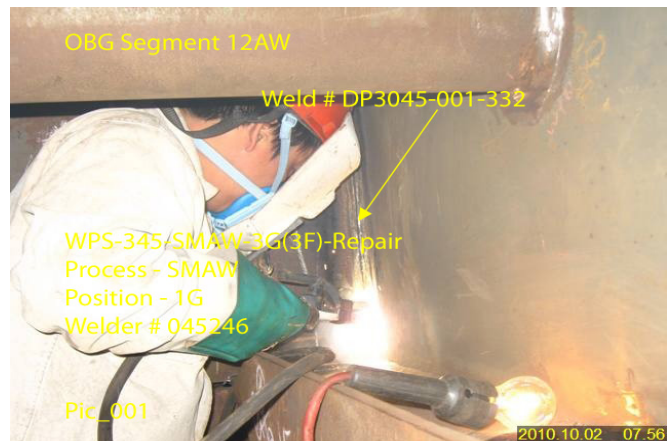
During in process inspection this QA Inspector observed ZPMC NDT personnel performing Magnetic Particle Testing (MT) on Bike Path side SP to Floor beam weld at PP110 East. See attached photograph Pic_002

OBG Segment 12AE

Shielded Metal Arc Welding (SMAW) in the various positions on various locations. The welder is identified as 037996. ZPMC Quality Control (QC) is identified as Li Ping.

OBG Segment 12AE

This QA inspector performed Visual inspection (VT) on Bottom Panel to Floor beam adjacent to Panel Point PP110 East & west side.



Summary of Conversations:

No relevant conversations reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By: Gade,Ramesh

Quality Assurance Inspector

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Reviewed By: McClendon, Timothy

QA Reviewer